

Date: Wednesday, 7/5/2006 2:48:30 PM
 User: Kim Johnston

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 350/212/130 BASKET LID |
| Job Number : 27815B | |
| Estimate Number : 10193 | |
| P.O. Number : N/A | Part Number : D2512 |
| This Issue : 7/5/2006 S.O. No. : N/A | Drawing Number : D2512 REV D2 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : D2 |
| Previous Run : 27578B | Material : N/A |
| Written By : <u>See Comment Below</u> | Due Date : 7/30/2006 Qty: 1 Um: Each |
| Checked & Approved By : <u>06 07 05</u> | |
| Comment : Rev Est:M 09.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M101309

PD

06-07-07

| | | |
|-----|--------|-------------|
| 2.0 | D31663 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3166-3 Basket Hoop

Batch

B21327

PD

06-07-07

| | | |
|-----|-------|---------|
| 3.0 | D2506 | Placard |
|-----|-------|---------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2506 Label Plate

Batch

B26631-2

PD

06-07-07

| | | |
|-----|--------|----------------|
| 4.0 | D23271 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2327-1 Bushing

Batch

B26742

PD

06-07-07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/5/2006 2:48:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27815B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B25238

PD

06-07-07

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B27524

PD

06-07-07

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M101358

PD

06-07-07

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

PD

06-07-24

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

11/06/07/24 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/5/2006 2:48:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27815B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/25 ①

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

m101560 spray
Batch: m101667 wing walk FC 07/26 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/10 ①

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/14 ①

Job Completion



C 06/08/14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
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| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

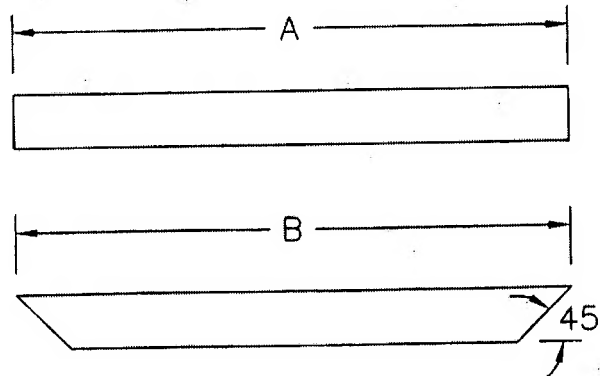


| | | | |
|------------------|----------------|--|------------------------|
| DESIGN BW | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2512 | REV. D SHEET 1 OF 4 |
| DATE 01.04.19 | | TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS | |
| A | 95.11.21 | NEW ISSUE | |
| B | 96.05.24 | ADDED LATCH CHANNEL & LABEL PLATE | |
| C | 99.07.06 | REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074 | |
| D | 01.04.19 | CHANGE HINGE | |
| D1 | CP 03.01.20 | ADD D2012-117 FOR D130-701-041 | |
| D2 | CP 09.09.20 | TACK WELD ANT-SKID AREA | |

RELEASED
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|---------------|
| D2512-1 | 2 | — | 25.50 | RIB |
| D2512-3 | 2 | — | 95.30 | RIB |
| D2512-5 | 6 | 30.84 | — | RIB |
| D2512-7 | 3 | 30.63 | — | RIB |
| D2232-1 | 2 | N/A | N/A | HINGE PLATE |
| D2236 | 4 | N/A | N/A | RIB |
| D2327-1 | 2 | N/A | N/A | BUSHING |
| D2506 | 1 | N/A | N/A | LABEL PLATE |
| D2581 | 2 | N/A | N/A | MOUNTING BRKT |



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NO. 27815B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

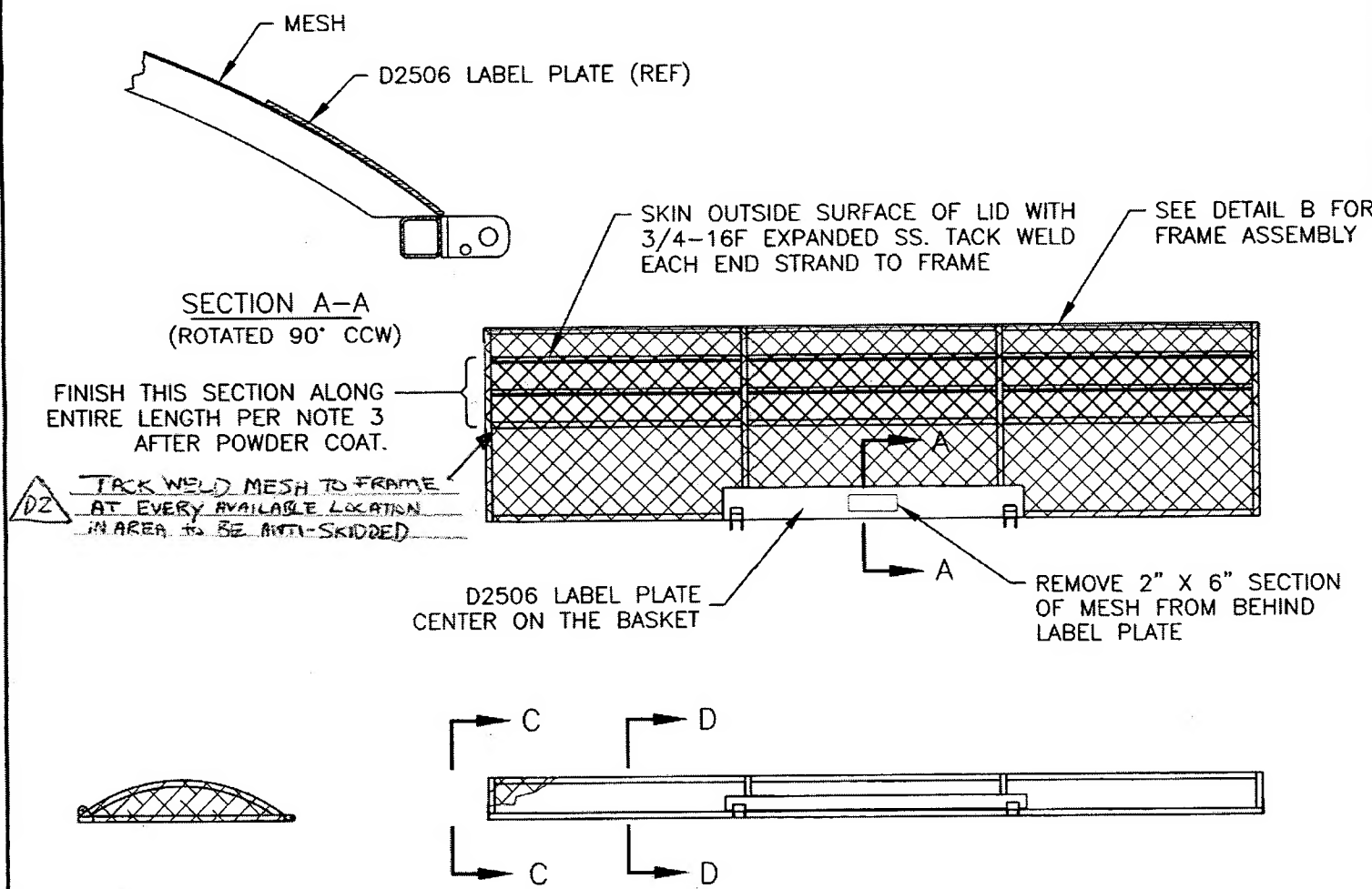
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| | | | | |
|---------|----------|----------|-------------------------------|---|
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| CHECKED | <i>+</i> | APPROVED | <i>+</i> | DRAWING NO. D2512 |
| DATE | 01.04.19 | TITLE | BASKET LID ASSEMBLY (350/212) | REV. D SHEET 2 OF 4 |
| | | SCALE | 1:20 | |



D2512 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

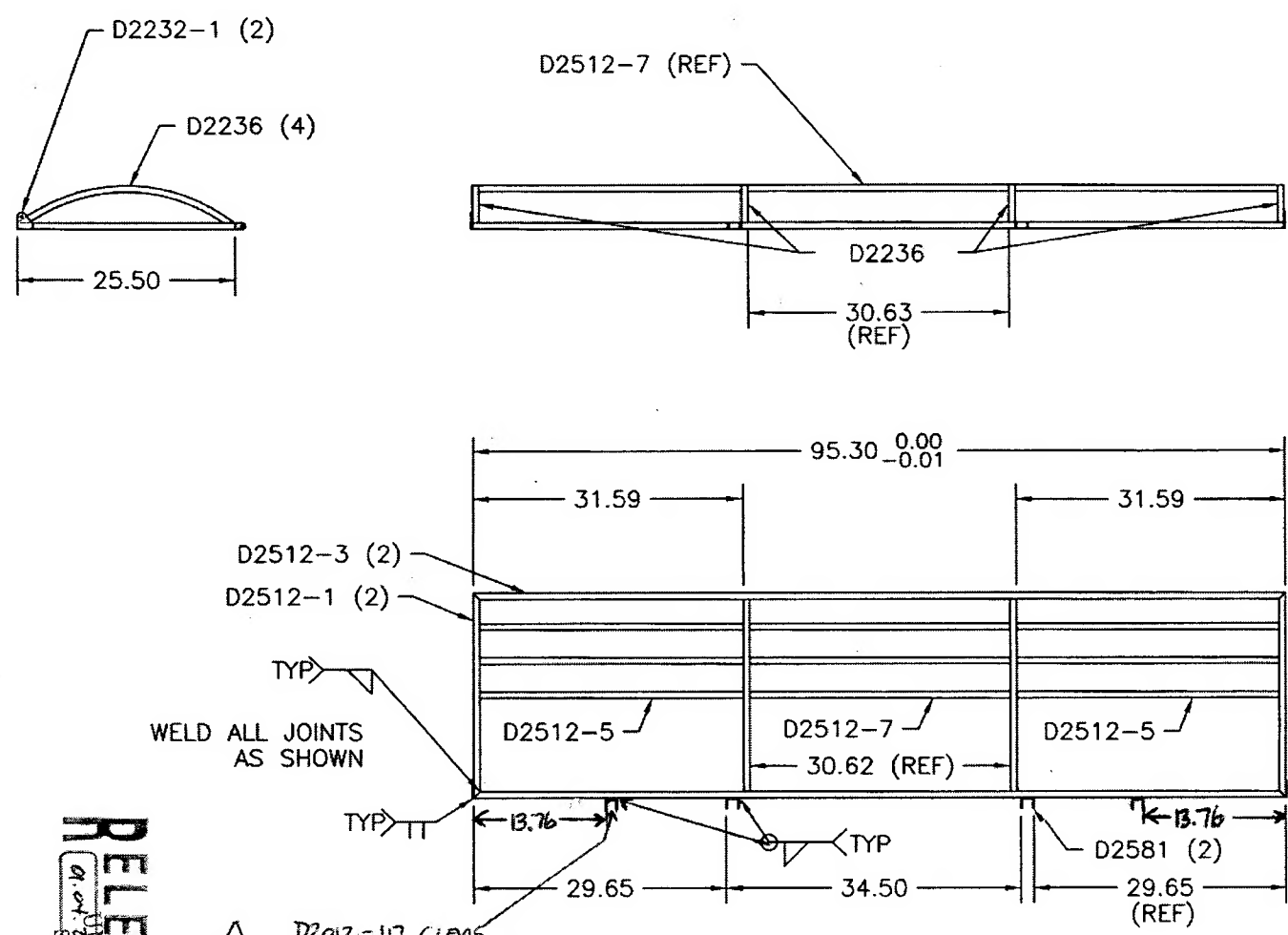
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NO. 278153

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| DATE | 01.04.19 | DRAWING NO. | D2512 | REV. D |
| | | TITLE | BASKET LID ASSEMBLY (350/212) | SHEET 3 OF 4 |
| | | | | SCALE 1:20 |



D2012-117 CLEMS
ADD FOR D130-701-041
ONLY (2 PLACES)

DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

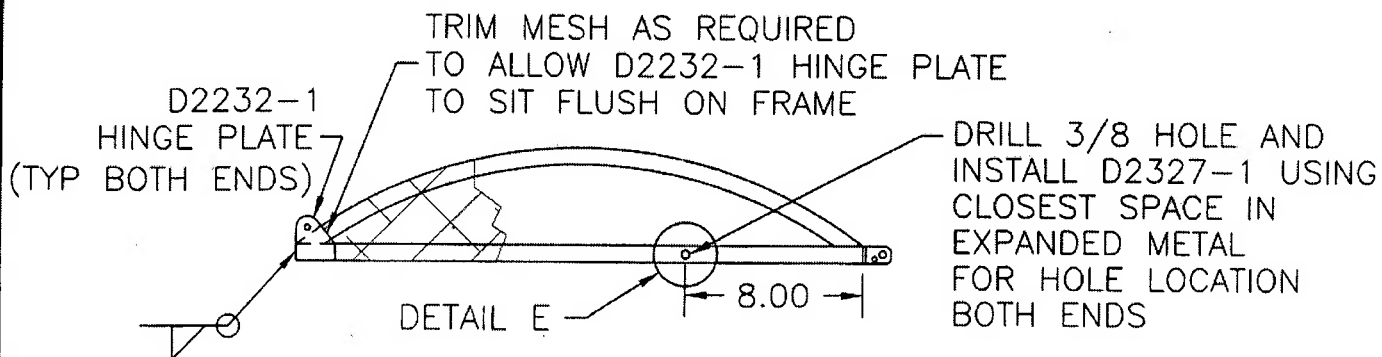
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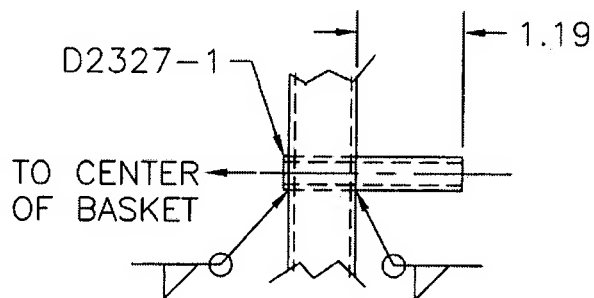
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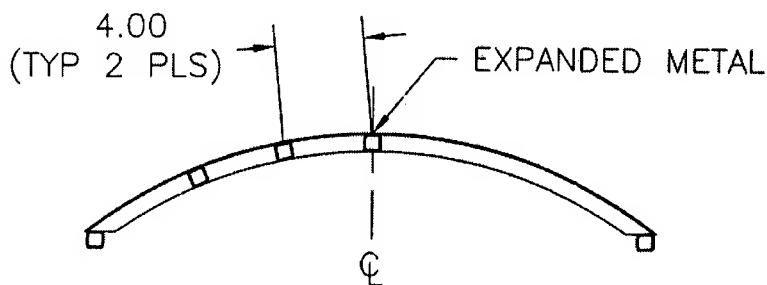
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| DESIGN BW | DRAWN BY UP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2512 | REV. D SHEET 4 OF 4 |
| DATE 01.04.19 | | TITLE BASKET LID ASSEMBLY (350/212) | SCALE 1:8 |



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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